

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004078**Date Inspected:** 28-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Sun Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:****OBG Bay 1**

The Caltrans QA observed ZPMC has approximately thirty (30) to forty (40) workers performing various functions relative to the fabrication of the OBG Deck Panels. These functions include; closed rib milling, PJP weld joint beveling, drilling thru holes, press forming, closed rib splice welding, closed rib diaphragm fit-up and FCAW welding of splices, closed rib to deck plate fit-up and tack welding and the PJP welding of closed ribs to deck plates. Deck Plates at the gantry stations were, Gantry-1 DP497-001 had SAW and GMAW completed previously. Gantry 2-DP411-001 had SAW and GMAW completed previously. Tack welding table had 3 deck panels in process for fit and tack welding which were DP540-001, DP545-001 and DP585-001. Caltrans QA inspectors received a notice of inspection from ZPMC for the diaphragm plates on DP585-001 which when this QA inspector arrived to perform the QA review for UT the closed ribs were already fit to the deck plate the QA inspector was not able to perform the QA review due to no access.

OBG Bay 3

This Caltrans QA observed ZPMC continuing with the fabrication of various Side, Bottom and Edge Panels designated for the SAS OBG. The general fabrication of said items consist of removal of coatings from weld joint areas, cutting, splitting of "W" shape beams for "T" stiffeners, splicing of plates, fitting, tack welding and welding. Various T stiffeners were in the beginning stage of being spliced a total of 14 were observed from fit-up to welding in process. This QA inspector received request for NDT witness in bay 3 on WT stiffeners CJP weld splice. This QA inspector performed the QA review after ZPMC had performed their UT testing of the areas and accepted these areas. The areas tested by ZPMC were 25% of the weldment as outlined in the contract documents. The items reviewed were SP576-001-037~048, SP616-001-037~048, SP536-001-043~056 and SP484-001-190~194. At the time of this QA inspectors review the weldments appeared to be within the contract

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documents for the 10% performed.



Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco , 1-381-694-2685, who represents the Office of Structural Materials for your project.

Inspected By:	Riley,Ken	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
